

Date: Wednesday, 14/05/2008 11:24:03 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 13-MAN SHOULDER HARNESS KIT (4 POINT)
Job Number : 39266	
Estimate Number : 10391	
P.O. Number :	Part Number : D412702021
This Issue : 14/05/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 14/05/2008 Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run : 38932	Material :
Written By :	Due Date : 05/06/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JUL 08 5.14</u>	
Comment :	
Est Rev:B Removed Manufacturing 05-11-08 JLM	
Est Rev:C 06.04.03 As per DSI9324 JLM	
est rev D 06.12.14 per ecn 871 EC	
Est Rev:E 07-03-14 As per DSI 9351 JLM	
Est Rev:F 07-07-28 As per Rev E JLM Verified By:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-702-021 CHG002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D412702069	Grommet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GROMMET KIT

Batch: 36449

4.0	D3195041	Bracket Assembly
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3195-041

Bracket

27840

39317 8/5/08

8/5/15

scf

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39266

Part Number: D412702021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3195043

Bracket Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3195-043 Bracket

27841

(2x)

8/5/28
2x SC
39318

SC

6.0

D31961

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

1 D3196-1 Bar

30146 (1x)

31466

SC

7.0

D31963

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

1 D3196-3 Bar

32136

SC

8.0

D31964

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

1 D3196-4 Bar

- 2

9.0

D3197041

Bar Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3197-041 Bar

30655 (2x)

37885 (2x)

SC

10.0

D31981

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 D3198-1 Fitting

1530604 (4x)

35282

8/5/15

SC

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Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D32681 Placard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3268-1 Placard 37777 (2x)

31468 (1x)

26338 (1x)

SP

12.0 D3446041 Harness Assembly



Comment: Qty.: 9.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

9 D3446-041 Harness Assembly 30130 (5x)

26777 (13x)

SP

13.0 D3446043 Harness Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 D3446-043 Harness Assembly 23599

SP

14.0 D355111 Hook and Loop Tie



Comment: Qty.: 13.0000 Each(s)/Unit Total: 26.0000 Each(s)

HOOK AND LOOP TIE

BATCH: 31217 (9x)

35151 (19x)

SP

15.0 D35461 Clip



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

CLIP

BATCH: 31216 (2x)

36455 (2x)

SP

16.0 AN45A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 AN4-5A

Bolt 106605

8/5/15

SP

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 39266

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 AN4-13A

Bolt

103363

107534

SP

18.0

AN420A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

8 AN4-20A

Bolt

10895

SP

19.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

20 AN960JD416

Washer

107321

SP

20.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

106051

SP

21.0

MS24694S152

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

8 MS24694-S152

Screw

101124

SP

22.0

MS24694S154

SCREW



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

SCREW

Batch:

103926

105057

8/5/15

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39266

Part Number: D412702021

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-021

Location: _____

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/05/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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QTY -021	QTY -023	QTY -025	QTY -027	QTY -029	QTY -035	Part Number	Description
X						D412-702-021	Dart 13-Man Shoulder Harness Kit, 4-point
	X					D412-702-023	Dart 5-Man Forward Facing Shoulder Harness Kit, 4-point
		X				D412-702-025	Dart 4-Man Aft Facing Shoulder Harness Kit, 4-point
			X			D412-702-027	Dart 4-Man Side Facing Shoulder Harness Kit, 4-point
				X		D412-702-029	Dart 1-Man Forward Facing Shoulder Harness Kit, 4-point
					X	D214-702-035	Dart 5-Man Aft Facing Shoulder Harness Kit, 4-point, for Bell 214B/B-1
1	1		1	1		D412-702-069	GROMMET KIT
2	2					D3195-041	BRACKET
2	2					D3195-043	BRACKET
1	1			1		D3196-1	BAR
1			1			D3196-3	BAR
1			1			D3196-4	BAR
2	2					D3197-041	BAR
4		4				D3198-1	FITTING
2	2					D3268-1	PLACARD
9	5		4	1		D3446-041	HARNESS ASSEMBLY, 4 POINT
4		4				D3446-043	HARNESS ASSEMBLY, 4 POINT
					5	D3446-045	HARNESS ASSEMBLY, 4 POINT
13	5	4	4	1	5	D3551-11	HOOK AND LOOP TIE
2	2					D3546-1	CLIP
4		4				AN4-5A	BOLT
4	4					AN4-13A	BOLT
8		8				AN4-20A	BOLT
20		20				AN960JD416	WASHER
12		12				MS21042L4	NUT (OR MS21042-4)
8	2		6	2		MS24694-S152	SCREW
8	2		6	2		MS24694-S154	SCREW

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 39266